

ABSTRACT

A casting roll unit (U) with side weirs (6) and a delivery nozzle (8) being detachably attached thereto is fixed at a casting position. Side-weir and delivery-nozzle preheating furnaces (29, 30) are arranged away from the casting roll unit (U). Arranged adjacent to the roll unit (U) are replacing robots (31, 32) which can selectively clamp the side weirs (6) or the delivery nozzle or nozzles (8) and which can move between the roll unit (U) and the side-weir or delivery-nozzle preheating furnace (29 or 30) for installation/removal of the side weirs (6) or delivery nozzle or nozzles (8).